

DART AEROSPACE LTD		Work Order: 40059
Description: contoured hinge arm		Part Number: PB6743001277
Inspection Dwg: PB6743001	Rev: B1	Page 1 of 1

pg 20

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.95	+ .030	.920	✓			
1.3	+ .030	1.316	✓			
.85	+ .030	.850	✓			
.55	+ .030	.550	✓			
.30	+ .030	.302	✓			
.75	+ .030	.749	✓			
1.00	+ .030	1.001	✓			
1.13	+ .030	1.125	✓			
.80	+ .030	.790	✓			
2.00	+ .030	2.990	✓			
.65	+ .030	.656	✓			
.25	+ .030	.256	✓			
1.25	+ .030	1.250	✓			
Ø.159	+ .005 - 0	.160	✓			
Ø.312	+ .006 - .001	.314	✓			
.425	+ .010	.425	✓			
.85	+ .030	.850	✓			
.70	+ .030	.70	✓			

Measured by: J.L.	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 08/06/28	Date: 08/06/28	Date: 08/06/28

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

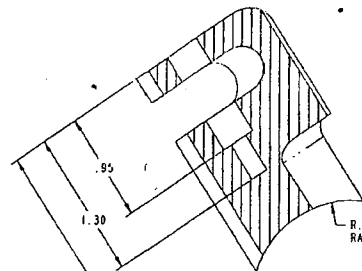
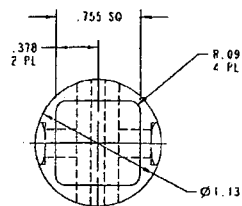
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

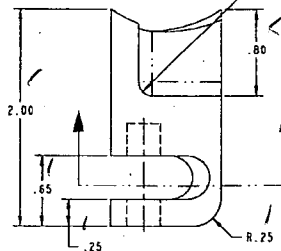
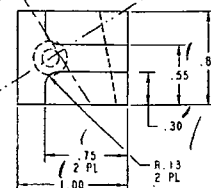
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40059

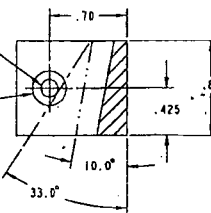


R.88
RADIUS CUT AT 15.0° ANGLE ROTATED C.C.W.



NO. 21 (.159) DIA HOLE
TAP 10-32 MIN. 1.200 DEEP

5/16 (1.312) DIA HOLE

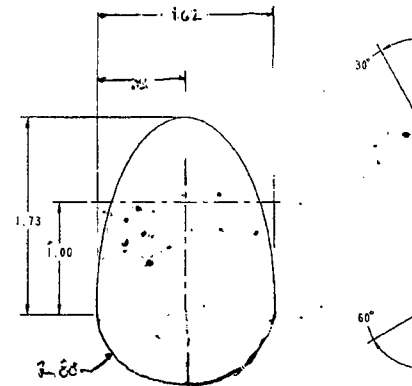


① JLM

②-277 CONTOURED HINGE ARM

MATL: 1:00-S0, -6061-16-00-A*200/8

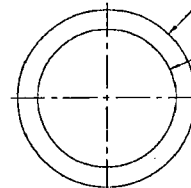
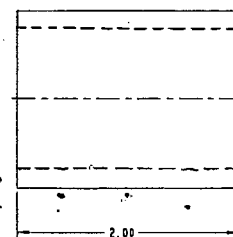
SCALE 2.000



①-233 OUTER TUBE END CAP

MATL: .063 THK. 6061-T6, 00-A-250/11
SCALE 2.000

RELEASED



③-265 TEFLO-BUSHING

MATL: TEFLO DELRIN
SCALE 2.000 (ACETON 60 PPM R.L.350)

④ 0103

PREMIER AVIATION, INC.			
2001 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	COMP	INSTR	DATE
D	OSUV8	B67-43001	81
SCALE	DTL	SHEET	20 of 45

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 10:01:51 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONTOURED HINGE ARM

Job Number: 40059

Part Number: PB6743001277

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 08/06/28 S

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *KT-E*

mf 08-07-09

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/10 *df*

Job Completion



mf 08-07-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 10:01:51 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CONTOURED HINGE ARM
 Job Number : 40059
 Estimate Number : 12071
 P.O. Number :
 This Issue : 25/06/2008 S.O. No. :
 Prsht Rev. : NC Part Number : PB6743001277
 First Issue : / / Type : MACHINED PARTS Drawing Number : B6743001 PAGE20
 Previous Run : Drawing Revision : B1
 Material :
 Due Date : 04/07/2008 Qty: 5 Um: Each
 Written By :
 Checked & Approved By : JLD 08.6.25
 Comment : Est. A05.07.19 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1250X01250 6061-T6 Bar 1.25 x 1.25"



Comment: Qty.: 0.1969 f(s)/Unit Total: 0.9844 f(s)
 6061-T6 Bar 1.25 x 1.25"
 Material: 6061-T6 Bar (QQ-A-200/8)
 (M6061T6B1.250x01.250)
 Identify for B67-43001-277
 Batch: 11107744

JLD 08/06/26

(5)

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 1.250" x 1.250" x 2.250" long

JLD 08/06/26

(5)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA544 and Dwg B67-43001
 Identify as B67-43001-277
 Dwg Rev B1
 Folio Rev AA

Manually tap part as per Dwg B67-43001
 Deburr

J.L 08/06/28

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/06/28